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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18512
Job Sheet 185716



Part No: RBT18512

Job Qty: 10 pcs

Part Name: Main Rotor Rotating Swashplate Bearing Removal



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18512 Rev.A IPP Rev. A 18.10.31 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Conventional Lathe - 1	10 pcs		12/7/18	0.00	1.00	Conventional Lathe - 1	
							Conventional Lathe - 2	
110	QC 2	10 pcs		12/7/18	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	



Container No: S143918



Part: RBT18512

Job No: 185716

Serial No/Batch: S143918

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/10/19

Plex 1/10/19 2:27 PM Dart.Hadley.Shannon

120 QC 8	10 pcs	12/7/18	0.00 0.00	QC 2 - 8	
				QC 8 - 12	
				QC 8 - 14	7/19/10/15
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
130 Outsource - 12 - Black Oxide	10 pcs	12/7/18		GRO002-VC	CC 19-01-15
140 Packaging 2-1 - Receive - B4B	10 pcs	12/7/18	0.00 0.00	Packaging 1 - 1 - B4B	
				Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	JAN 21 2019
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
150 QC 6	10 pcs	12/7/18	0.00 0.00	QC 6 - 16	

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38
9-89

				QC 6 - 38	
				QC 6 - 42	
				QC 6 - 9	
				QC 6 - 68	
160	Packaging 3-1 - Stock - B4B	10 pcs	12/7/18	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
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					Packaging 3 - 30 - B4B
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					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
170	QC 21 - FG	10 pcs	12/7/18	0.00 0.00	QC 21 - FG - 16
					QC 21 - FG - 21
Part Op 100 - 1-Machine as per DWG. 2-Debur Descriptions: 120 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG. Buff after engraving. 130 - -Issue P/O; 042380 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM -Certificate of Conformity is required					
GA 211					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MT-A513-T-5.250W0.375	ASTM A513 Type 5 Alloy Steel Round Tubing 5.250 Dia, 0.375 Wall	2.6600 ft (.266 ea)	100-Conventional Lathe - 1	S132038	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Conventional Lathe - 1	MT-A513-T-5.250W0.375	3	12	3
Allocated Container Detail				
Qty	Container No	Location	Init	
3	S143899	wj-2		
Part Specifications				
Specifications could not be found.				

Plex 1/10/19 2:27 PM Dart.Hadley.Shannon



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110	QC 2	10 pcs		12/7/18	0.00	0.00	QC 2 - 1			19/1/10
120	QC 8	10 pcs		12/7/18	0.00	0.00	QC 8 - 12			
130	Outsource - 12 - Black Oxide	10 pcs		12/7/18			GRO002-VC			
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170	QC 21 - FG	10 pcs		12/7/18	0.00	0.00	QC 21 - FG - 16			

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Descriptions: 120 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG. Buff after engraving.

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-A513-T-5.250W0.375	ASTM A513 Type 5 Alloy Steel Round Tubing 5.250 Dia, 0.375 Wall	2.6600 (.266 ea)	100-Conventional Lathe - 1	S132038

Location US2 (water Jet area)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Conventional Lathe - 1	MT-A513-T-5.250W0.375	3	0	0

Part Specifications

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA_Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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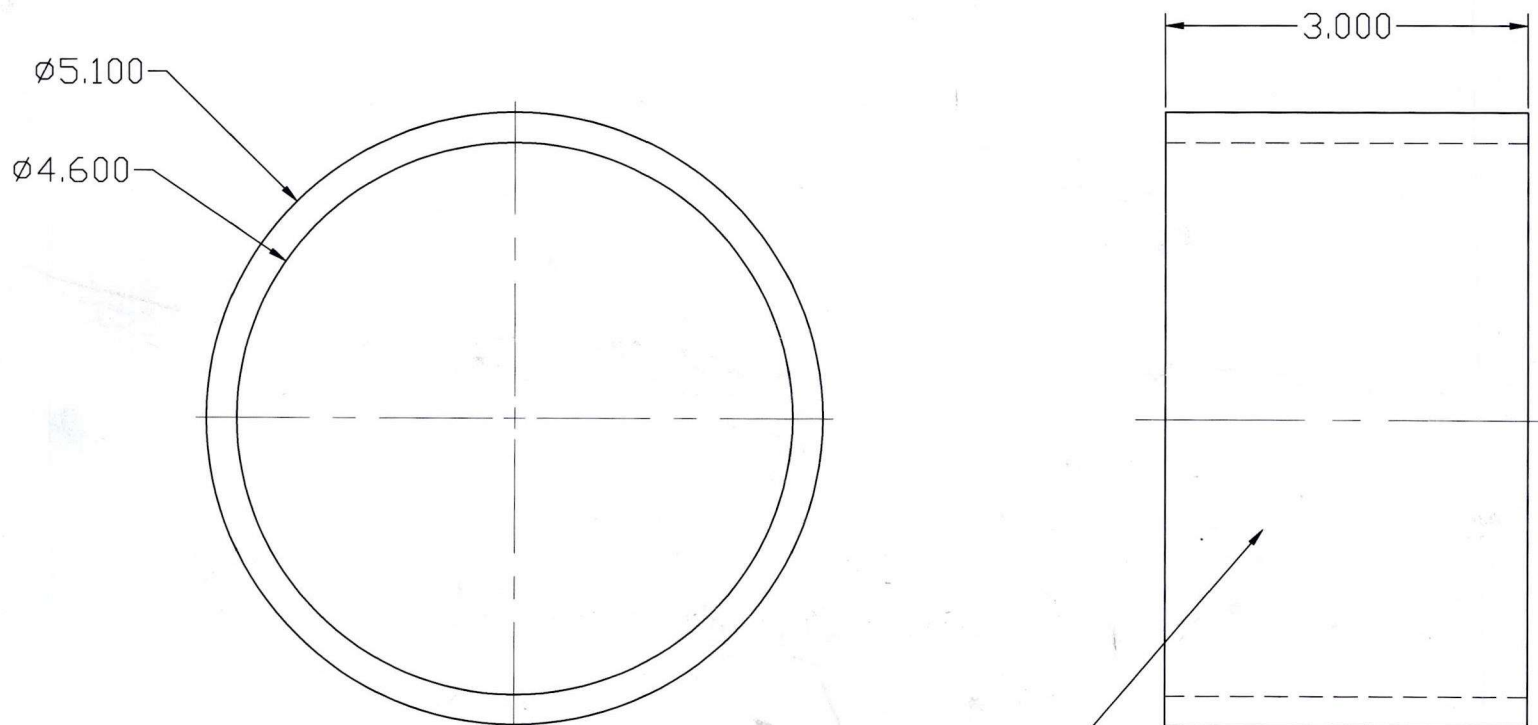
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This drawing, specifications, and concepts contained herein are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
A	CH'D TITLEBLOCK & REVISION BLOCK, ADDED ENGRAVE NOTE.	12/29/09	RJC RW



ENGRAVE T/N, S/N,
"MADE IN USA"
BUFF AFTER ENGRAVING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185116
MCS

18-10-31

NOTE:
USE TO REMOVE M/R
ROTATING SWASHPLATE BRG.

ASSY QTY	ASSY #	B/D PART #	QTY	DESCRIPTION	MATERIAL	B/D INFORMATION OR SPECIFICATIONS
			1	M/R BRG. SLEEVE	DOM	Ø5-1/4" OD x 3/8" WALL x 3

RED BARN MACHINE	
TITLE M/R BRG. SLEEVE	
DWG NO. RBT18512	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON DECIMALS	APPROVED
.XXX ± .005	FRACCTIONS ± 1/32
.XX ± .01	ANGLES ± 5°
.X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 5-6-05
SHEET 1 of 1	

11-12-12 345 // 745-120-1245 2008
1 3/4 4/4 1 1/4



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042280



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042280
PO Date: 1/15/19
Due Date: 1/18/19
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments: *revised*

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185716	RBT18512	Main Rotor Rotating Swashplate Bearing Removal -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM -Certificate of Conformity is required	Firmed	-	1/18/19	10 pcs	0 pcs	10 pcs	\$10.95/pcs	\$109.50
10 x JAN 21 2019											
Line Item Note *need asap*											
2	188639	RBE2-10-1-01	Slide -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C- 16173 GRADE 4 -Certificate of Conformity is required	Firmed	-	1/18/19	7 pcs	0 pcs	7 pcs	\$6.00/pcs	\$42.00
7 x JAN 21 2019											



Dart Aerospace Ltd.
1270 Aberdeen St
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PURCHASE ORDER

PO042280



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	188454	RB6796941-16	Punch -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM -Certificate of Conformity is required	Firmed	-	1/18/19	6 pcs	0 pcs	6 pcs	\$3.05/pcs	\$18.30

6x JAN 21 2019

Grand Total: \$169.80

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/16/19 10:09 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(016009-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

016009 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
18-Jan-2019		Aman		042280 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT18512 ✓ Rev.	RBT18512 BLACK OXIDE PER MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL, WIPE OFF EXCESS	BLACK-OXIDE CH	10	10 ✓	0	0	0
2	RBE2-10-1-01 ✓ Rev.	RBE2-10-1-01 BLACK OXIDE PER MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL, WIPE OFF EXCESS	BLACK-OXIDE CH	7	7 ✓	0	0	0
3	RB6796941-16 ✓ Rev.	RB6796941-16 BLACK OXIDE PER MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL, WIPE OFF EXCESS	OXIDE-BLACK CH	6	6 ✓	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.